

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005337**Date Inspected:** 03-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Xu Xian Ping
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG components**Summary of Items Observed:**

On the date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 7-OBG Assembly

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld joints# 003,004,007,008,011 & 012 located on PCMK SP 204-001. Welders are identified as 205385,062447 & 048810. ZPMC QC is identified as Cui Jun Jie. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

Welding of weld joints# 058 & 059 located on PCMK SP 500-001. Welders are identified as,062447.ZPMC QC is identified as Cui Jun Jie. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

Bay# 6-OBG Assembly

This QA Inspector randomly observed the following work in progress:

Magnetic Particle Testing:

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For Green Tag

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date. The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. SP 734-001 019,021,022,023 003902 9 EW
2. DP 520-001 075 003903 2 A
3. DP 519-001 041 003904 2 A
4. DP 524-001 051 003905 3 A

For Yellow Tag:

Sl # Section # Weld # Yellow Tag # Location

1. SSD1-DPSA3-6 8 NA NA

Bay# 2-OBG Assembly

This QA Inspector randomly observed the following work in progress:

Magnetic Particle Testing:

For Yellow Tag

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date. The member and the weld designations are as follows:

Sl # Section # Weld # Yellow Tag # Location

1. LD 023-001 007,005,008 003318 NA
2. LD 024-001 007,005,008 003319 NA
3. NSD 1-SA363 13 NA NA

Unless otherwise noted, all work observed on this date appeared to be generally comply with applicable contract document

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
